

Work Order ID 70018

Wednesday, May 25, 2011 12:03:25 PM



Page 1

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/05/25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: A

Prog Rev: A

***graind direction along 28.100" ***

2-Deburr if necessary

B11-5-30



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70018

Wednesday, May 25, 2011 12:03:25 PM

Page 2

Item ID: D3023-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Back Panel

Start Date: 5/25/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S u l o s t 3

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using
D3017-041 back frame

S u l o s t 3

2-EL 11-6-10

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S u l o s t 3

40

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70018

Wednesday, May 25, 2011 12:03:25 PM



Page 3

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 11-6-13.

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:30

□OVEN TEMPERATURE:

□FINISH TIME:

9:00

3250 F

1X of m-11/6/13

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BL 11-6-13.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70018

Page 4

Wednesday, May 25, 2011 12:03:25 PM

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

W/O 70005

0.00

Packaging

E 5/11/06/13

190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/6/14**CL 11/06/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 12:03:23 PM

Page 1

Work Order ID: 70018

Parent Item: D3023-1

Parent Item Name: Back Panel



Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.032		Purchased	No			100	sf	39.9000	2.8777	3.029158			
--------------	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--



2024-T3 .032 sheet



B11-5-30

Location

Loc Qty

Loc Code

MAT22

39.9

111699

0.5

113189

39.4

113189



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

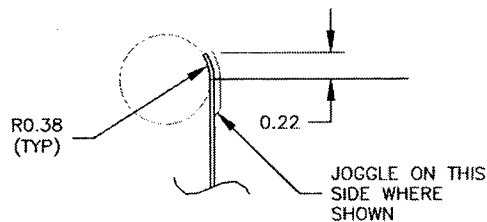
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

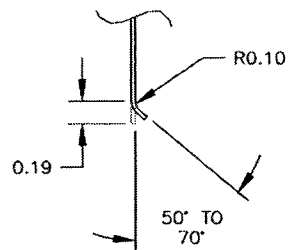
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

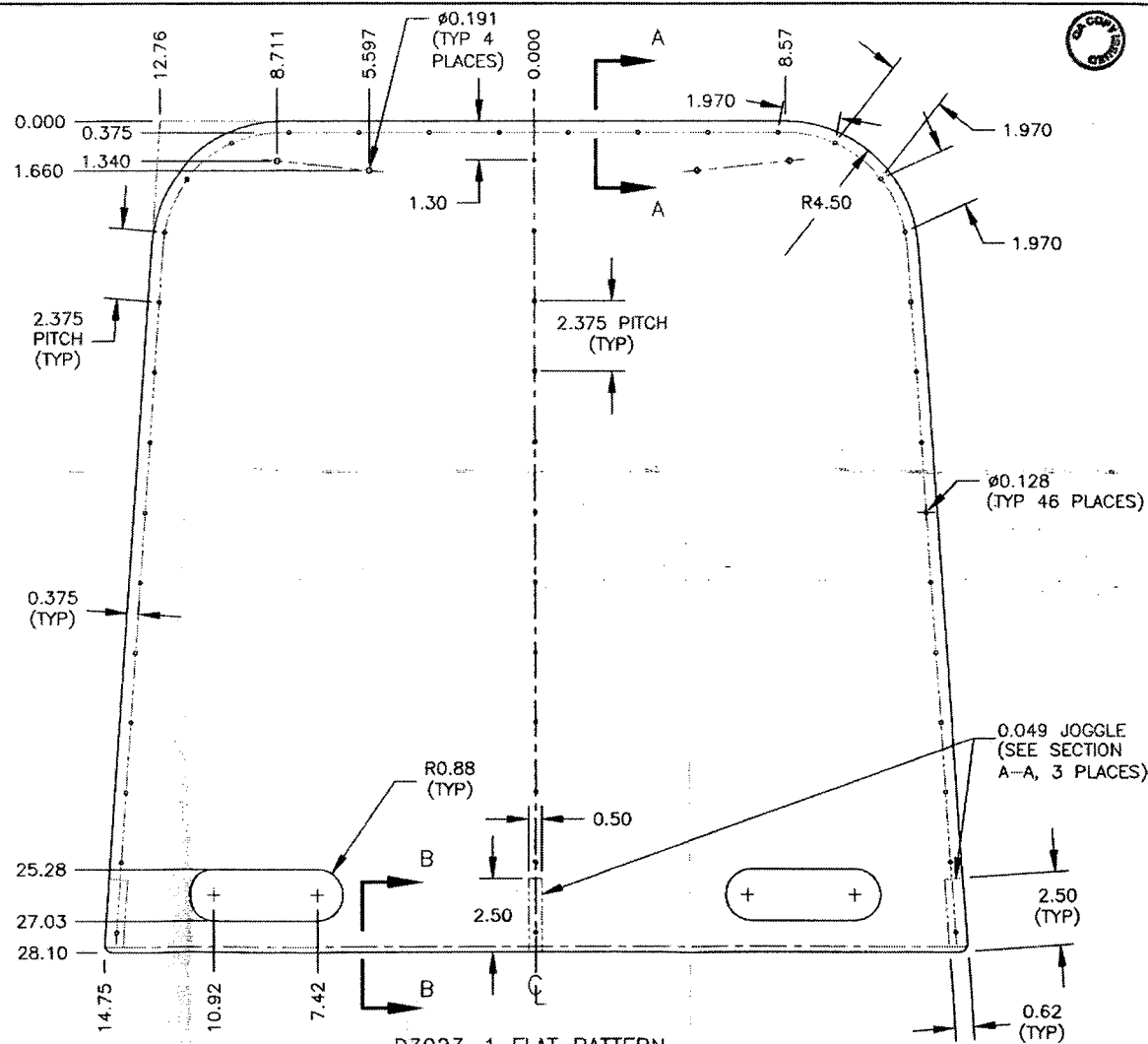


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

CL 11/05/25
W/D: 70018

COPYRIGHT © 2001 BY DART AEROSPACE LTD.		01.05.18		NEW ISSUE	
DESIGN	UP	DRAWN BY	UP	DART DART AEROSPACE LTD. <small>HANESBURY, ONTARIO, CANADA</small>	
CHECKED	UP	APPROVED	UP		
DATE	01.05.18	DRAWING NO.	D3023	TITLE	BACK PANEL
				REV. A	SHEET 1 OF 1
				SCALE	1:4

DART AEROSPACE LTD		Work Order:	70018
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131	✓		V HBZ	
Ø0.191	+0.005/-0.001	.191	✓		V	
1.660	+/-0.010	1.658	✓		V	
0.375	+/-0.010	.378	✓		V	
1.340	+/-0.010	1.342	✓		V	
2.375	+/-0.010	2.374	✓		V	
0.375	+/-0.010	.376	✓		V	
25.28	+/-0.030	25.28	✓		T HB01	
27.03	+/-0.030	27.03	✓		T	
28.10	+/-0.030	28.10	✓		T	
1.30	+/-0.030	1.300	✓		V	
2.375	+/-0.010	2.377	✓		V	
8.711	+/-0.010	8.710	✓		PRO WSSZ	
5.597	+/-0.010	5.595	✓		V	
8.57	+/-0.030	8.57	✓		P	
1.970	+/-0.010	1.970	✓		V	
7.42	+/-0.030	7.42	✓		V	
10.92	+/-0.030	10.92	✓		P	
14.75	+/-0.030	14.75	✓		T	

Measured by:	RB
Date:	11-5-30

Audited by:	[Signature]
Date:	11/05/30

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC [Signature]	[Signature]

